

Date: Thursday, 4/12/2007 9:33:03 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LATCH
 Job Number : 31777
 Estimate Number : 12772
 P.O. Number : *N/A*
 This Issue : 4/12/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 31020
 Part Number : 41232 200 002 003
 Drawing Number : 41232-200-002 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 5/10/2007 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : *[Signature]*
 Comment : Est Rev: A New Issue 07-03-05 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3R1875 2024 T3 ROUND BAR 1.875



Comment: Qty.: 0.3675 f(s)/Unit Total : 2.9400 f(s)

2024-T3 Round Bar 1.250" 1.875

Batch: *12775 17892**SG 07-04-28**W*2.0 ~~LATHE CONV.~~ *HARDINAGE* CONVENTIONAL LATHE

Comment: CONVENTIONAL LATHE

Turn as per Dwg 41232-200-0021

*SG 07-04-28**W*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SG 07-04-28**W*4.0 ~~MILLING CONV.~~ *OK* CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE

Mill as per Dwg 41232-200-002

2-Deburr

*JL/JF 07/05/01**9*

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*JL/JF 07/05/01**9*

6.0 QC8 SECOND CHECK

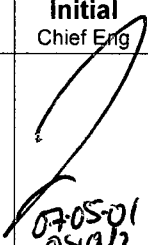
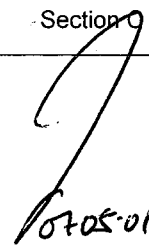
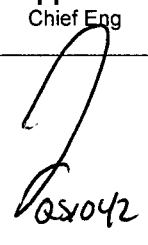
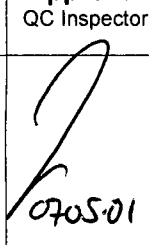


Comment: SECOND CHECK

*SD 07/05/01**9**3.1 HAAS.**Mill as per photo fa688.**JF 07/05/01**9*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/11
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------|---------------------------------|----------------|-------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/04/30 | 4 | 1 part is scrapped - error in new pgm - rad tool was plunging into the part |  070501 05/02 | - scrap + re place - fix pgm | J.L |  0705-01 |  05/042 |  0705-01 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:33:03 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH

Job Number: 31777

Part Number: 41232 200 002 003

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 3680

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

C267105102 (7)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

267105110 (8)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

267105110 (9)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

267105110 (10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(11)

Job Completion



267105111

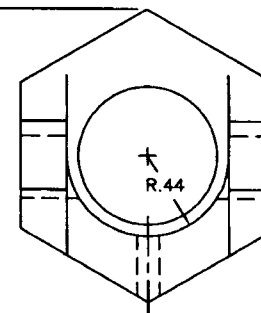
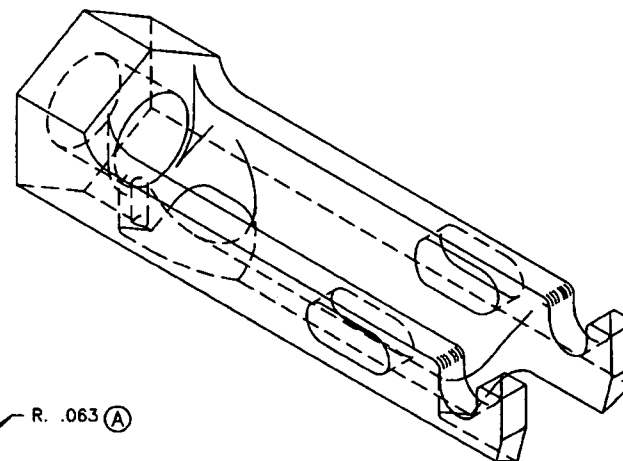
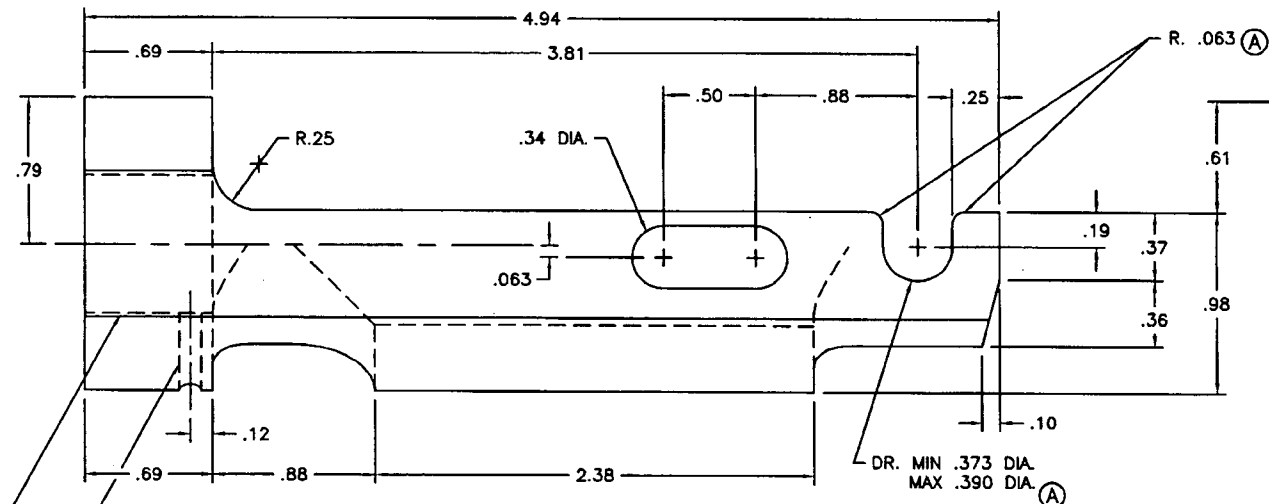
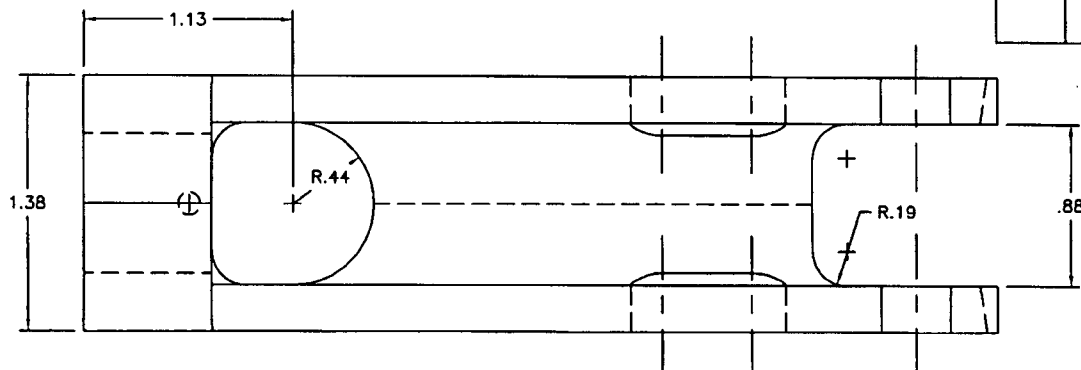
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



-001 TUBE

DR. .12 DIA. DRAIN HOLE
(NOTE: SPOTFACE IF REQ'D
TO DRILL HOLE)

3/4"-20 THD.

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 317777

ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2
DYED BLACK.

NOTE:

| | | | | | |
|---|--------------|-----------|----------------------|---------------------|----------|
| 1 | MS21209F4-15 | INSERT | | | |
| | -005 | PIVOT ARM | 1.00 DIA. x 3.56 | 2024-T4, T351 ALUM. | |
| | -003 | LATCH | 1.11 x 3.50 | 2024-T4, T351 ALUM. | |
| | -001 | TUBE | 1.38 HEX STK. x 4.94 | 2024-T4, T351 ALUM. | |
| | -005 | PART NO. | NAME | STOCK SIZE | MATERIAL |
| | | | | | MATLSPEC |
| | | | | | ZONE |

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NOT APPLY TO
VENDOR PARTS.

| | | |
|---|---------------|---------------|
| 2 | 41232-200-001 | NEXT ASSEMBLY |
|---|---------------|---------------|

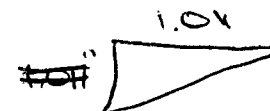
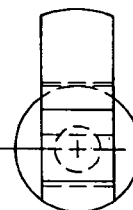
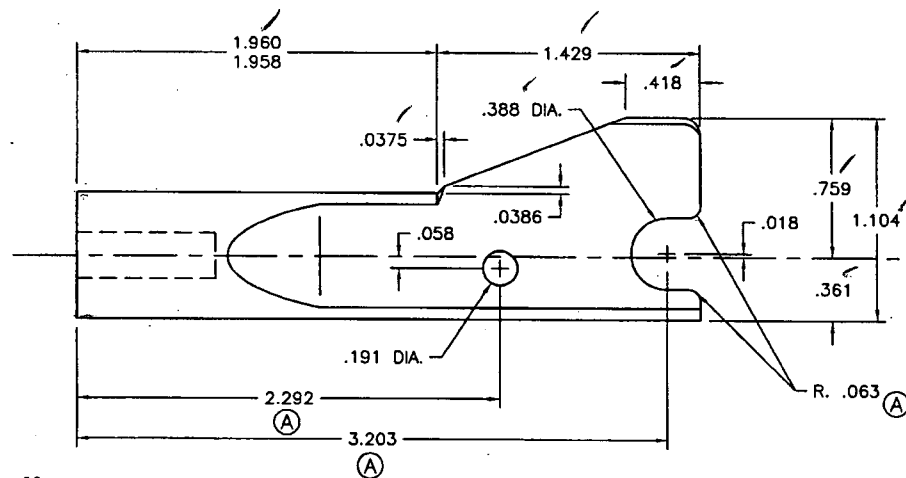
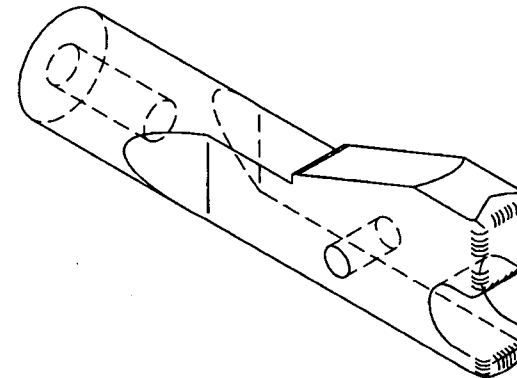
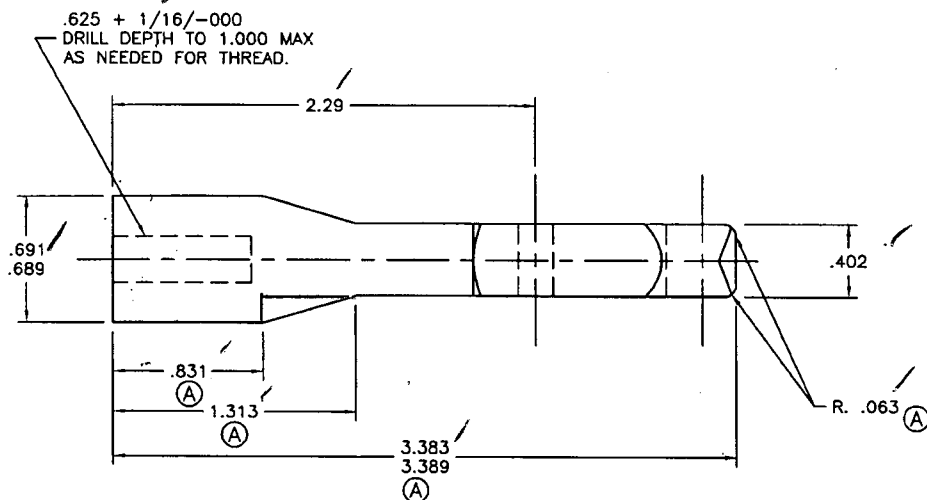
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| | | | |
|-------------|-----------|---------|-------|
| DRAFTSMAN | D. NELSON | 2/18/02 | TITLE |
| CHECK | D. MURPHY | 2/18/02 | |
| STRESS | | | |
| PROD. ENGR. | | | |
| HEAT TREAT | | | |
| FRESH | | | |

| | | | |
|-----------|---------------|-------|-----|
| DRG. SIZE | C | SCALE | 2:1 |
| DRG. NO. | 41232-200-002 | REV. | A |
| SHT | 1 OF 3 | | |

Eva Aviation, Inc.

STEP ACTUATOR
COMPONENTS



Handwritten signature

-003 LATCH

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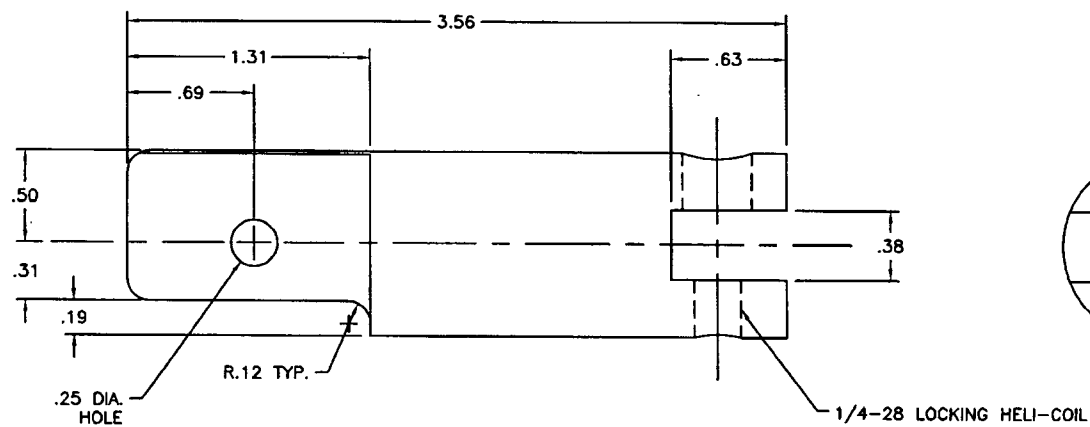
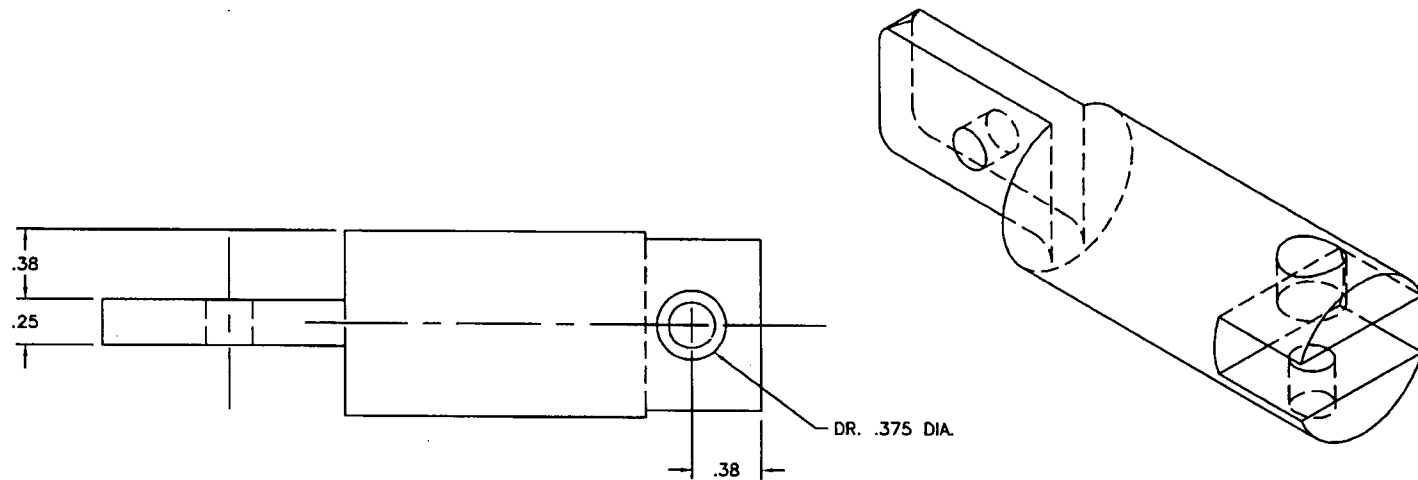
Era Aviation, Inc.

TITLE
STEP ACTUATOR COMPONENTS

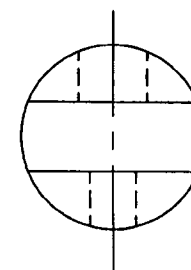
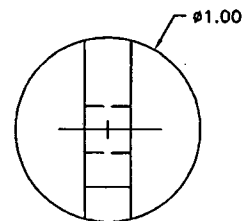
SIZE
C

DWG. NO.
41232-200-002
SHT 2 OF 3

REV.
A



-005 PIVOT ARM



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Era Aviation, Inc.

| | | | |
|--------------------------|------|-----------------------------|------|
| TITLE | SIZE | DRAW. NO. | REV. |
| STEP ACTUATOR COMPONENTS | C | 41232-200-002 SHT 3 OF 3 | A |

| | | | |
|-----------------|-------------------|--------------------------------|----------------|
| DATE 2/26/04 | ENGINEERING ORDER | E.O. No. B-1 | SHT. 1 OF 1 |
| BY D. NELSON | | DWG. AFFECTED 41232-200-002 | |
| APPROVED BY | | SHEET AFFECTED SHT 1 & 3 | |

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

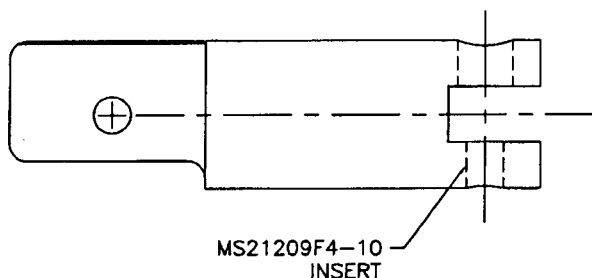
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|---|--------------|--------|

WAS

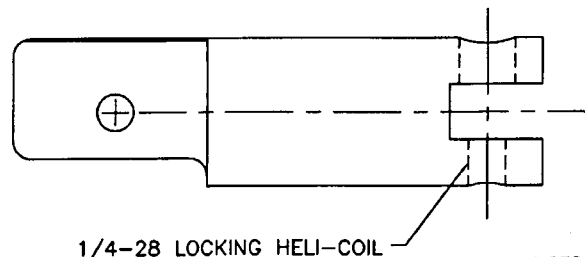
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|---|--------------|--------|
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|---|--------------|--------|

IS



-005 PIVOT ARM

WAS



-005 PIVOT ARM
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 WITHOUT NOTICE
 WORK ORDER
 NO. 31777

| CHANGE REQUIRED: | DATE: | BY: | YES | NO |
|-----------------------------|-------|-----|-----|----|
| TRAVELER | | | | |
| INSTALLATION INSTRUCTIONS | | | | |
| MAINTENANCE INSTRUCTIONS | | | | |
| ILLUSTRATED PARTS | | | | |
| UNINCORPORATED DRAWING LIST | | | | |
| MASTER DRAWING LIST | | | | |
| COMPUTER DATA BASE | | | | |

| | |
|-----------------------------------------------------------------------------------------------|---------------------------------------|
| DART AEROSPACE LTD | Work Order: 31777 |
| Description: <i>Catch</i> Crosstube Assembly <i>Step indicator array</i> | Part Number: 41232-200-002-003 |
| Inspection Dwg: 41232-200-002 Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| | Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------|---------------------------------------|----------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 689-691 | | .6905 | ✓ | | | |
| | 1.958-1.960 | ±.000 -.010 | .995 | ✓ | | | |
| | | | 1.960 | ✓ | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| SIDE B | .402 | ±.010 | .402 | ✓ | | | |
| | 1.063 | " | .063 | ✓ | | | |
| | 3.386 | ±.003 | 3.386 | ✓ | | | |
| | 1.313 | ±.010 | 1.313 | ✓ | | | |
| | .831 | ±.010 | | | | | |
| | 1.429 | ±.010 | 1.428 | ✓ | | | |
| | .388 | " | .388 | ✓ | | | |
| | .418 | " | .418 | ✓ | | | |
| | .0375 | " | .037 | ✓ | | | |
| | .759 | " | .759 | ✓ | | | |
| | 1.104 | " | 1.104 | ✓ | | | |
| | .361 | " | .362 | ✓ | | | |
| | Ø.191 | ±.005 -.001 | .193 | ✓ | | | |
| | 2.292 | ±.010 | 2.293 | ✓ | | | |
| | 3.203 | " | 3.205 | ✓ | | | |

| | | | |
|--------------------------------------|------------------------------|----------------------------|-----|
| Measured by: <i>BC/SJ/J.F</i> | Audited by: <i>SA</i> | Prototype Approval: | N/A |
| Date: <i>07/05/01</i> | Date: <i>07.05.01</i> | Date: | N/A |

| | | | | |
|------------|-------------|---------------|-------------------|-----------------|
| Rev | Date | Change | Revised by | Approved |
| A | | New Issue | KJ/JLM | |

TNM**ANODISATION et PEINTURE TNM INC.****FACTURE
INVOICE**

21 chemin de l'Aviation, QC H9R 4Z2
Telephone: (514) 429-7777 Fax: (514) 429-5108
Certifié ISO 9001-2000 / ISO 9001-2000 certified
Certifié NADCAP / NADCAP certified

55027**04-May-2007****CLIENT / CUSTOMER:**

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY , ONTARIO
K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE:**

P000003680**CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

| ITEM | COMMANDE ORDERED | EXPEDIE SHIPPED | PART NUMBER & DESCRIPTION | PREX UNITAIRE UNIT PRICE | EXTENSION |
|------|---------------------|--------------------|---------------------------|-----------------------------|-----------|
| 1 | 26 | 26 | VARIOUS | \$0.00 | \$0.00 |
| | | | LOT PRICE | | \$130.00 |
| | | | | SUB TOTAL: | \$130.00 |
| | | | | TPS/GST: | \$7.80 |
| | | | | TVQ/PST: | \$0.00 |
| | | | | TOTAL AMOUNT DUE: | \$137.80 |

BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

No de TPS / GST # : 891559734 RT
No de TVQ / QST # : 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.